

### **Abstract of the Disclosure**

**An article of manufacture for a hollow one piece plastic injection molded bicycle frame with a hollow plastic injection molded bicycle frame with the ability to attach a front fork assembly, a seat assembly, a pedal crank assembly and, rear wheel assembly, a plastic injection mold to produce a bicycle frame that is one piece hollow and free from welding and brazing, the ability to select from a variety of polymers (plastic resin) to produce a one piece hollow bicycle frame depending on the bicycling application, a mold which produces a tin bismuth core of a bicycle frame, and a plastic injection mold which produces a plastic bicycle frame.**